

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-106 Date Opened: 23-June-17 Title: AssemblyAircraft OEM: Airbus Helicopters Aircraft Model: AS350 Product Type: Bike Rack Product Model: Base Quantity: 2 LH / 2RH**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

DM

N/A

DM

DM

N/A

N/A

N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC

JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100215	0	Bike Rack Base Ass'y	DM

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

2 / 2

N/A

N/A

N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A

N/A

JC

N/A

JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A

N/A

N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC

N/A

N/A

Work performed by:

Print: D. Martyn

Sign: 

SCA: AD05

Date: 25-Jun-17

ICC / Dual Inspection performed by:

Print: J. Rekve

Sign: 

SCA: AD01

Date: 25-Jun-17

Work Order closed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 15-Aug-17

Approved Manufacturing Facility 73-04

Form 20.1/03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BEAM No. of pieces: 2

Manufacturer: AERO DESIGN LTD

Part No.: 100230-01 Serial/Batch No.: PO 16058

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-101

Remaining Tasks to be Performed: INSTALL

Signature: JH Ceyl.

Date: 26 JUNE 2017 Lic. No. / SCA A002

Serviceable



Aero Design Ltd.

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AMF 73-04

Remarks

Serviceable



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AMF 73-04

Nomenclature: Beam No. of pieces: 4 of 36

Manufacturer: Aero Design Ltd.

Part No.: 100230-01 Serial/Batch No.: 16058

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2016-118

Remaining Tasks to be Performed: weld in place.

Signature: David [Signature]

Date: For Aug 31 / 2016 Lic. No. / SCA AD-05

Form# 20.E.03 Rev. 1 24 April 2014

In Process



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AMF 73-04

In Process

Remarks



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9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

Nomenclature: Beam AMF-73-04 Stack
No. of pieces: 18 36 pc.
Manufacturer: Aero Design Ltd
Part No.: 100230-01 Serial/Batch No.: 16058
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2016-118
Remaining Tasks to be Performed: CNC operations, deburr,
weld in place ✓
Signature: [Signature]
Date: Aug 31st / 2016 Lic. No. / SCA AD-07

In Process



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AMF 73-04

In Process

Remarks

17 Completed 09/09/2016 AD02

1 completed 29/03/2017 AD02



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AMF 73-04

Nomenclature: BIKERACK BASE No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 100215-01-02 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-106

Remaining Tasks to be Performed: clean up, inspect
powder coat ✓ ✓ ✓

Signature: [Signature]

Date: June 25/2017 Lic. No. / SCA AD-05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder Coat 17065 ✓



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BIKE RACK BASE No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 100215-01-02 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-106

Remaining Tasks to be Performed: clean up, inspect
powder coat ✓

Signature: [Signature]

Date: June 25/2017 Lic. No. / SCA AD-05

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder Cont 17065 ✓



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

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AMF 73-04

Nomenclature: BIKERACK BASE No. of pieces: 1

Manufacturer: AERO DESIGN LTD

Part No.: 100215-01-01 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-106

Remaining Tasks to be Performed: clean up, inspect
powder coat ✓ ✓ ✓

Signature: David Dwyer

Date: June 25/2017 Lic. No. / SCA AD-05

In Process



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AMF 73-04

In Process

Remarks

powder cont 17065 ✓



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bike Rack Base No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 100215-01-01 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-106

Remaining Tasks to be Performed: Clean up, inspect
powder coat ✓ ✓ ✓

Signature: [Signature]

Date: June 25/2017 Lic. No. / SCA AD-05

In Process



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AMF 73-04

In Process

Remarks

Powder Coat 1706.5 ✓

$$2 R/H \quad 2 L/H$$

SHEET 1 OF 1	AD	100213	0	
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2 R/H 2 L/H

Aero Design Ltd. Component Fabrication

Work Order Number: 2017-106

100215-01 Bicycle Rack Base

Date: June 23/2017

Notes:

Drilling speed to 320 RPM.

Rapid Tap cutting fluid or equivalent coolant required

Rail

Tasks

SCA

1.	Record material PO below	AD-05
2.	Cut 78230 step extrusion to 82.75" in length	P.C.W
	On each end, cut the side and bottom walls shorter by 1/8" leaving the tread rail full length IAW drawing 100215 Detail B	P.C.W
3.	Deburr one end on buffing wheel	P.C.W
4.	On the bottom wall, place a mark 7/8" from each end and drill 3/8" hole which will act as a drain and allow ventilation during the welding process	P.C.W

Manual Mill

5.	While supporting the long end of the rail, clamp aft end (dependant on LH or RH) into the manual mill vice	P.C.W
6.	Using standard practices, zero off of the end and back of the part and set zero on the X and Y axis on the digital display	P.C.W
7.	Set table to drill locations IAW drawing 100215 Detail C and bore .75" holes	P.C.W
8.	Deburr edges and holes	P.C.W

Welding

9.	Wipe parts with Acetone or equivalent solvent	P.C.W
10.	Place 100226-01 bushings in .75" holes and locate them IAW drawing 100215 Detail C	P.C.W
11.	Weld IAW drawing 100215	P.C.W
12.	Place cap 82720-04 on each end and weld IAW drawing 100215 Detail B	P.C.W

Beam

13.	Cut 1" x 8" 6061-T6 extruded bar to 24 7/8" in length.	P.C.W
14.	Install material in CNC mill ensuring RH edge overhangs for tool clearance	P.C.W
15.	Set material stop to ensure subsequent steps and parts return to the same location	P.C.W
16.	Load and run program 021 and 022	P.C.W
17.	Rotate part 180 degrees on plane	P.C.W
18.	Load and run program 021 and 022	P.C.W
19.	Separate parts by cutting along mark scribed during machining process	P.C.W

20.	Install 100230 jig plate into CNC straddling vices and lock down	P.C.W.
21.	Using a soft face hammer, tap the jig down to ensure it is seated	P.C.W.
22.	Zero table using standard practices	P.C.W.
23.	Mount separated part on jig using 1/4" bolts	P.C.W.
24.	Load and run program 023	P.C.W.
25.	Using vertical band saw, remove tooling lug at the outboard end	P.C.W.
26.	On manual mill, zero off the end of the part using standard machining practices	P.C.W.
27.	Using standard practices, machine surface area from which lug was removed	P.C.W.
28.	Inspect finish and dimensions of final part.	OK

Rack Base Assembly

29.	Insert Helicoils in threaded bushings IAW drawing 100226	P.C.W.
30.	Install bike rack base beams into jig fixture	AD-OS
31.	Install rails into beams	AD-OS
32.	Weld IAW drawing 100215	AD-OS
33.	Inspect finish and dimensions of final part.	OK
34.	Tag completed parts IAW Aero Design MPM.	AD-OS

Material Purchase Order Number See P.D.S.

Batch Quantity 2 R/H 2 L/H


$$\mathbb{Z} \quad \mathbb{R}/\mathbb{H}$$
 2 L/H

WO# 2017-106

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013